

Work Order ID 119832

May-27-14 10:54:58 AM

119832

Page 1

Item ID: 646.3314

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blade

Start Date: 5/27/14 Start Qty: 20.00

20

Cust Item ID:

Required Date: 6/13/14 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
646.3300	N/C								

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank at 5.050"

20 Ø 14/07/17

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB147

DWG REV: N/C

FOLIO REV: N/C

20 Ø DAS 44 14/07/20 9-89

2- deburr and break all sharp edges except otherwise noted

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Start Date: 5/27/14 Start Qty: 20.00

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Cust Item ID:

Required Date: 6/13/14 Req'd Qty: 20.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00				20	0		DAS 44 9-89 14/07/20
120									
QC	Memo	0.00							
Quality Control									
130	QC8- Inspect parts - second check	0.00				20			DAS 25 9-89 14-7-21
130									
QC	Memo	0.00							
Quality Control									
140	Outsource process - Heat Treat	0.00							
140									
Outsource1	Memo	0.00							
Outsource process - Heat Treat	HEAT TREAT AS PER DWG, SEE NOTE #3								
	ISSUE P/O: 25157								

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Item ID: 646.3314 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Blade
 Start Date: 5/27/14 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 6/13/14 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC14- Inspect Spray Paint	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <u>MF</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

20X DAS
28
9-88 AUG 12 2014

MLD 14-08-12
MLJ 14-08-12

Picklist Print

May-27-14 10:54:57 AM

Page 1

Work Order ID: 119832

119832

Parent Item: 646.3314

646.3314

Parent Item Name: Blade

Start Date: 5/27/14

Required Date: 6/13/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 12/11/07 JFS VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MSTEEL-A2- B0.500X1.250		Purchased		No		100	f	169.8430	0.421	9			

MSTFFI -A2-B0 500X1 250

AISI A2 TOOL STEEL BAR, 0.500 X 1.250

Location

MAT006

M126438

M127494

Loc Qty

169.843

120

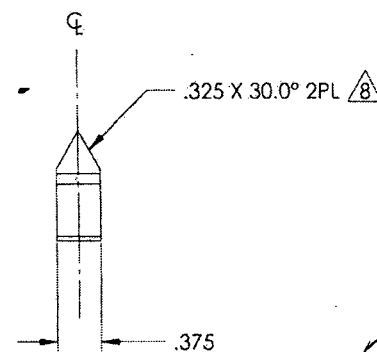
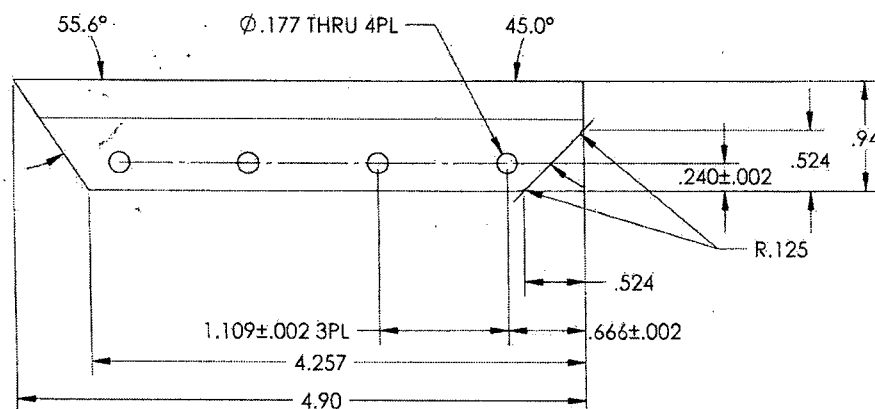
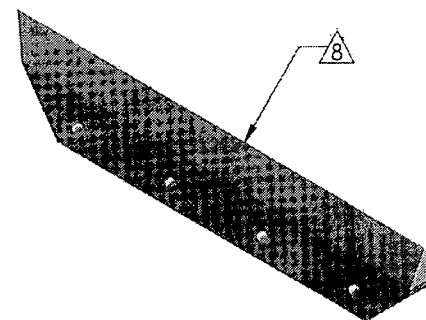
49.843

Loc Code

8.5'
14/07/14

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APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REV.	DESCRIPTION	DATE	APPROVED



W10119832

646.3314

<small> ORIGINAL DATE: 05/24/06 DRAWN BY: J. HUNTER CHECKED BY: J. HUNTER DESIGNED BY: J. HUNTER APPROVED BY: J. HUNTER CONTRACT NO. </small>		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
<small> UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5° </small>		SHEET: B CAGE CODE: 07M26 DATE: 07/26/06	REV: N/C PART NO: 646.3300 SCALE: NONE
		SHEET 6 OF 8 UPPER CUTTER ASSY	

DART AEROSPACE LTD	Work Order: 119832
Description: Blade	Part Number: 64603314
Inspection Dwg: 64603314 Rev: N/C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 177	+0.005/-0.001	177	✓		FK-04	Vern
94	+/- 0.010	93.2	✓		"	"
524	+/- 0.005	524	✓		"	"
240	+/- 0.002	240	✓		"	"
524	+/- 0.005	524	✓		"	"
666	+/- 0.002	666	✓		"	"
1.109	+/- 0.002	1.109	✓		"	"
4.257	+/- 0.005	4.257	✓		"	"
4.90	+/- 0.010	4.890	✓		"	"
375	+/- 0.005	375	✓		"	"
325 x 30°	+/- 0.005 / +/- .5°	325 x 30°	✓		"	"
45°	+/- .5°	45°	✓		A-G	
55.6°	+/- .5°	55.6°	✓		"	
R.125	+/- 0.005	.125	✓		R-G	

DAS		DAS		Preliminary Approval:	
Measured by:	44 9-89	Audited by:	25		
Date:	14/07/20	Date:	9-89	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	-

10.04.15



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO25157**

Purchase Order Date 7/25/2014

PO Print Date 7/25/2014

Page Number 1 of 2

Order From :
METCOR INC.
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC J7R 5A8
CA

VC-MET004

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 450 473 1884

Ship To Contact
Ship To Phone
Ship Via: FedEx PI ppd
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	121406	646.9711 BLADE	8/13/2014 Yes 8/13/2014		30.00	\$0.00	\$0.00
FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS							
PART ARE MADE FROM AISI A2 TOOL STEEL							
PLEASE NOTE: DETAIL C OF C REQUIRED							
Line Total:							\$0.00
2	119832	646.3314 BLADE	8/13/2014 Yes 8/13/2014		20.00	\$0.00	\$0.00
FINISH: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS							
PART ARE MADE FROM AISI A2 TOOL STEEL							
PLEASE NOTE: DETAIL C OF C REQUIRED							

Note:

7/25/2014

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
197677	1	83393

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

LIVRÉ À /Shipped To

DART AEROSPACE

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
25157		A2	2014/7/28	FEDEX

QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight
----------------------	-------------------------	--------------------------------	---	-----------------

50 BLADE

15,

(30) 646.9711

(20) 646.3314

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BOITE DE CARTON	1	

EMPAQUETAGE Packing	
-------------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 50

POIDS EXPÉDIÉ / Weight Shipped : 15,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

QUANTITÉ EXPÉDIÉE /Quantity Shipped: 50

POIDS EXPÉDIÉ / Weight Shipped : 15,00

Signature:

Date:

EXPÉDIÉ LE / Shipped On : 2014/07/31

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450-491-6454

Rapport d'Inspection**Inspection Report**

BON DE TRAVAIL order	CHARGEMENT load
197677	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY


ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
25157				
<p align="center">SPÉCIFICATIONS DU PROCÉDÉ processing specifications</p> <p>VAC HARDEN</p> <p>HARDEN AND TEMPER</p>				
<p>EXIGENCE / requirement SPÉCIFICATIONS / specified TESTS EXÉCUTÉS / performed RÉSULTATS DE TESTS / results</p> <p>HARDNESS 58 - 62 HRC 5 60 - 61 HRC</p>				
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
50	15	BLADE (30) 646.9711 (20) 646.3314		

COMMENTAIRES / comments

APPROUVÉ par / Approved by:




DATE: 2014-07-31

8
14/08/14